



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Order 1440

RBW6205G11231-3G

Job Sheet 173108



Part No: RBW6205G11231-3G

Job Qty: 1 ea

Part Name: AW139 Swashplate Assembly Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6205G11231-3G REV 0 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/9/18	0.00	0.00	Start Up Small Fab-4		MCC
110	Small Fab	1 pcs		3/9/18	0.00	0.00	Small Fab-4		MCC
120	QC	1 pcs		3/9/18	0.00	0.00	QC4		7/10/18
130	Packaging	1 pcs		3/9/18	0.00	0.00	Packaging3-1		18/5/18
140	QC21-FG	1 Ea		3/9/18	0.00	0.00	QC21		Y.A.

Part Op
Descriptions: 110 - 1-Assemble RBW6205G15231-3G and RBW6205G13831-3G

DAS

Job BOM

MAY 22 2018

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G13831-3G	AW139 Swashplate Kit Box 2	1 Ea (1 ea)	90-Start up Operation	5071824
RBW6205G15231-3G	AW139 Swashplate Kit Box 1	1 Ea (1 ea)	90-Start up Operation	5071716

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW6205G13831-3G	1	0	0
	RBW6205G15231-3G	1	0	0

Part Specifications

Specifications could not be found.

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



Work Order update only

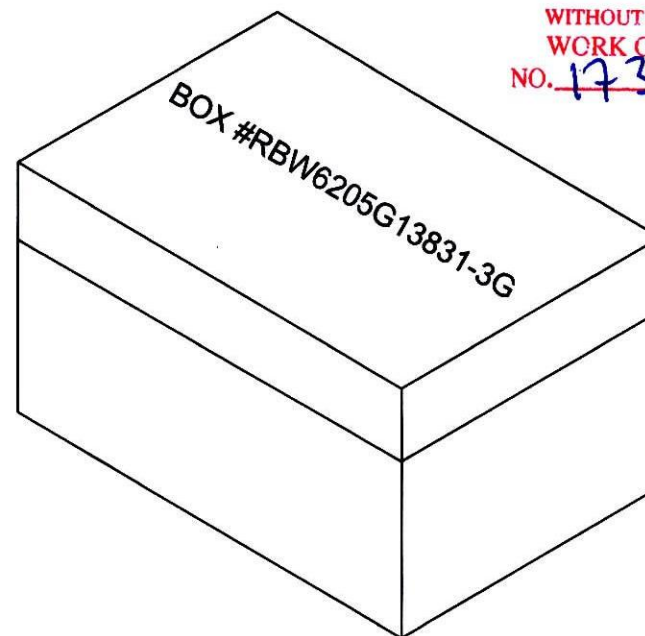
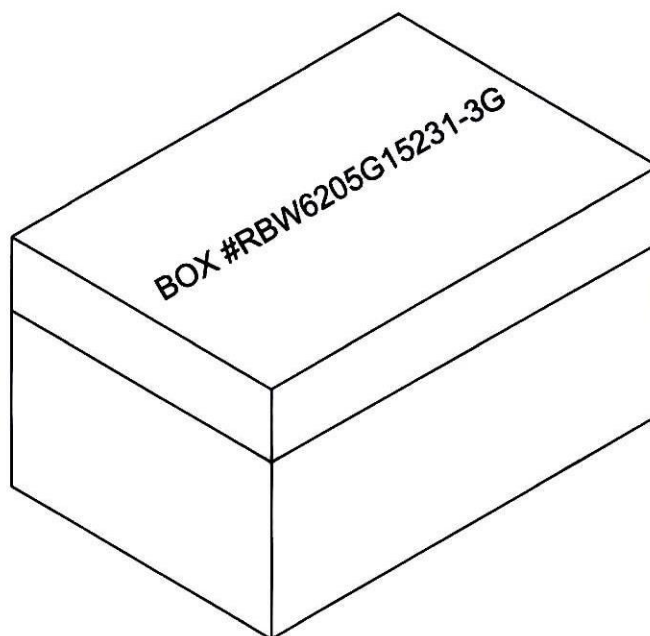
Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																	
Part No. _____		Rework ☐		Engineering ☐																																																	
NCR No. _____		Scrap ☐		Quality ☐																																																	
		Use-as-is ☐		Other ☐																																																	
		Suspected Unapproved ☐		Ther ☐																																																	
Date : _____		Step #: _____		(QSI042) Approval _____																																																	
Description Work Order Deviation				Completed By _____																																																	
				Hand / Supervisor _____																																																	
				Approval Verification _____																																																	
				QA Coordinator _____																																																	
				Approval _____																																																	
Root Cause <table border="1"> <tr> <td>Environment ☐</td> <td>No Re-verification ☐</td> <td>Pressure/Forced ☐</td> <td>Tempera ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> <td>Set-up ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> <td>BOM/Ro ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td>Broken/I ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspecti ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td>Contami ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Counters ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too ! ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructi ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Hole ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="2"></td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> <td colspan="2">OTHER : _____</td> </tr> </table>				Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Tempera ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Ro ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/I ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspecti ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contami ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Counters ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too ! ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructi ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Hole ☐	Past Expiry Date ☐	Manufacturing Process ☐			Misidentified ☐	Past Due ☐	OTHER : _____		Date: 05/17/18 Inspector: _____ Revision: 0 Serial No/Batch: S072237 Job No: 173108 Part: RBW6205G11231 - 3G  Container No: S072237 CART AEROSPACE 1270 Aberdeen Street Hawkebury, OH 43417 CANADA TEL: 1 613 632-6200 Email: sales@dartaero.com www.dartaerospace.com	
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Tempera ☐																																																		
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
-	--	-	-

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 173108 MJS
18-02-26



ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	BOX 1		RBW6205G15231-3G	1
			-3	1	BOX 2		RBW6205G13831-3G	1
ASSY #								

RED BARN MACHINE	
TITLE AW139 SWASHPLATE KIT	
DWG NO. RBW6205G11231-3G	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 XX ± .01 X ± .1	
METRIC REF. XXmm ± .1mm FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-31-11
SHEET 1 of 1	
DRAWN BY CLOUGH	
APPROVED <i>D. West</i>	
HEAT TREAT	
FINISH	
SPEC	
USED ON MODEL AW139	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

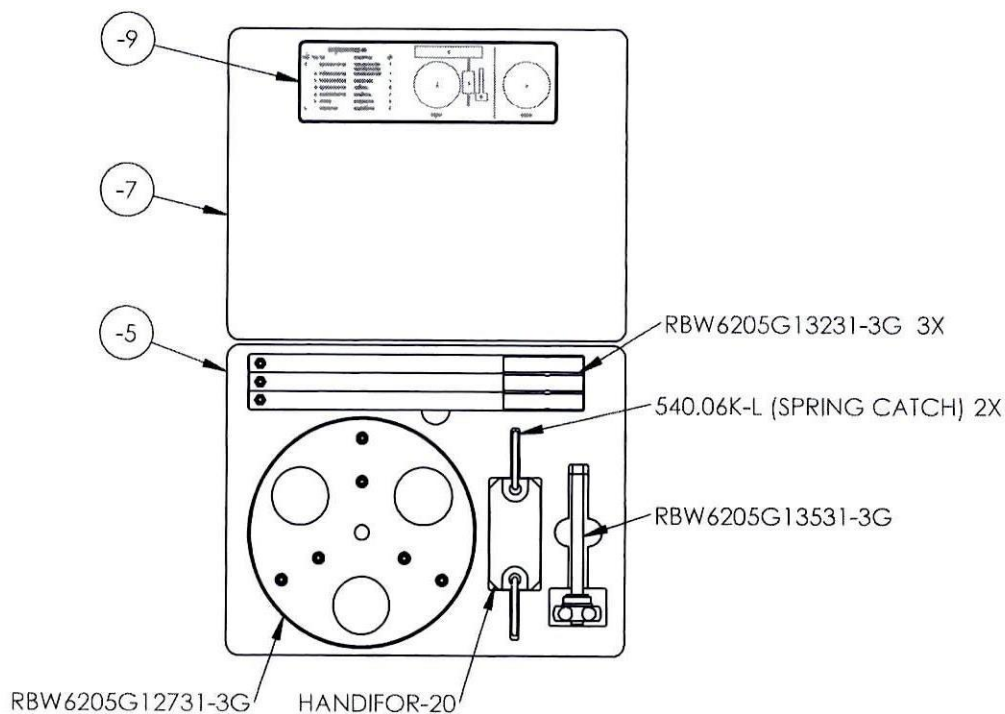
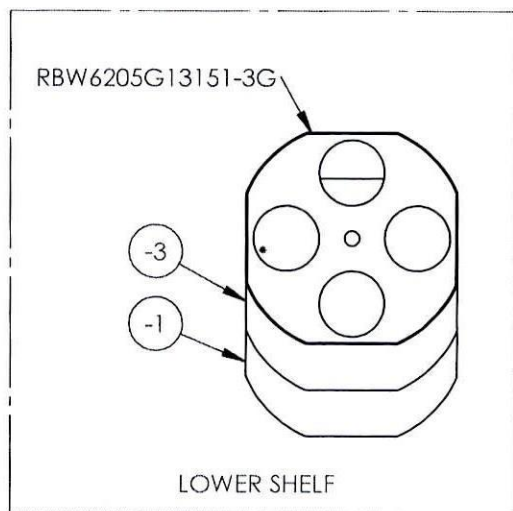
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		-1 & -3 ADDED NOTE. -5 CH'D OVERALL DIMENSIONS TO FIT CASE TIGHTER. -7 CH'D OVERALL DIMENSIONS TO FIT CASE TIGHTER, CH'D CUTOUT TO RECESSED POCKET ADDED CUTOUT ON BOTTOM FOR CASE PIN CLEARANCES AND MATERIAL FROM C200 FLAT TO 1780 FLAT BLACK.	6/29/2011	RJC
2	15-0151	-5 CH'D CUTOUT SIZE AND DEPTH FOR -11 & -13, CH'D DIM WAS $\nabla 1.00$ IS $\nabla 1.60$ FOR RBW6205G13231-3G. -7 CH'D FOAM WAS 1780 FLAT, BLACK IS Y20 BLACK. CH'D CUTOUT DEPTH FOR PLACARD WAS .063 IS .13. -9 REMOVED TEXT "CONTENT LIST", CH'D DESCRIPTION WAS PLACARD IS LOCATION PLACARD.	7/8/2015	RJC



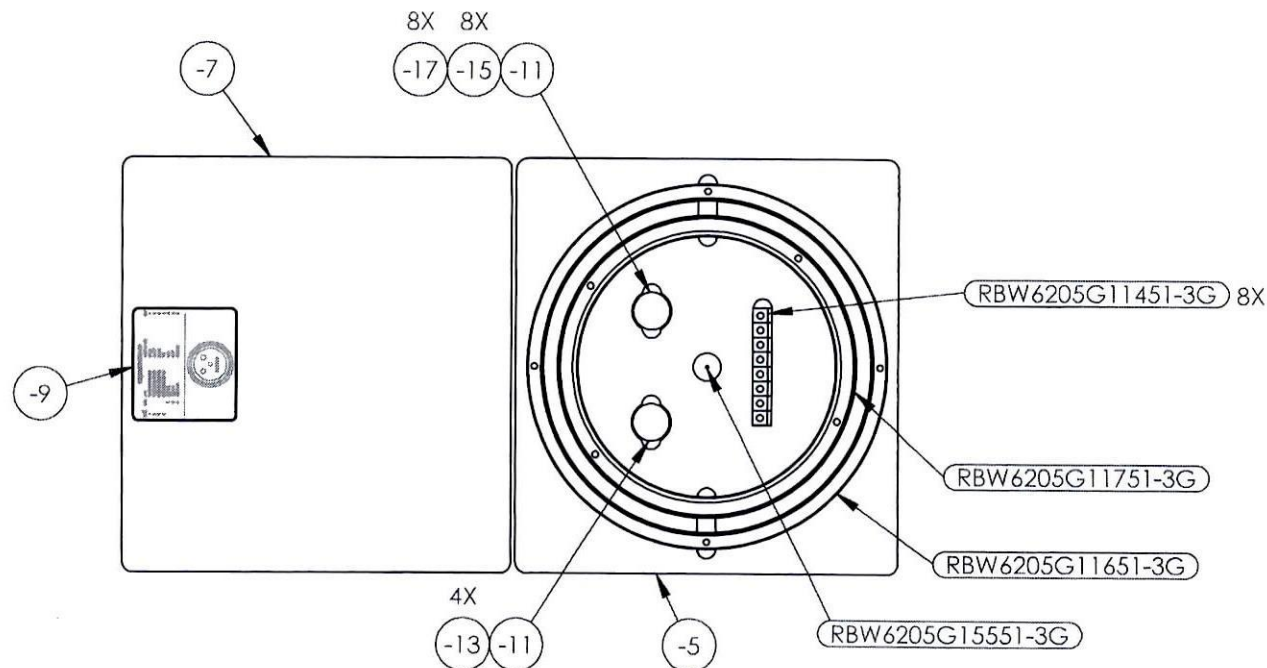
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	UPPER PLATE ASSEMBLY		RBW6205G12731-3G	1
				1	LOWER PLATE		RBW6205G13151-3G	1
				3	ARM ASSEMBLY		RBW6205G13231-3G	1
				1	SCREW ASSEMBLY		RBW6205G13531-3G	1
		B/O	-1	1	SHELF BACKING	COROPLAST	BLACK, 6mm $\varnothing 12-7/16$ I.R. SPECIALTY	2
		B/O	-3	1	SHELF	Y20 BLACK	$\varnothing 12-7/16$ X $13/16$	3
		B/O	-5	1	BOTTOM FOAM	Y20 BLACK	6-1/8 X 16-3/4 X 21-3/4 I.R. SPECIALTY	4
		B/O	-7	1	LID FOAM	Y20 BLACK	1-3/4 X 16-3/8 X 21-5/16 I.R. SPECIALTY	5
			-9	1	LOCATION PLACARD	PLASTIC		6
		B/O	-11	1	DYNAMIC METER		HANDIFOR-20	7
		B/O	-13	2	SPRING CATCH	S.S.	$\varnothing 5/16$ CARABINER STYLE (MCMASHER-CARR #3777112)	1
		B/O	-15	1	CASE	PLASTIC, BLACK	8 X 17 X 20 PELICAN #APP-1600-E	N/S
		B/O	-17	1	DART PLACARD	ALUMINUM	#RB41011	N/S

NOTE:
PART OF KIT RBW6205G11231-3G.

DART AEROSPACE	
TITLE AW139 SWASHPLATE KIT	
DWG NO. RBW6205G13831-3G	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 FRACTIONS $\pm$ 1/8 .XX $\pm$.01 ANGLES $\pm$ 5° .X $\pm$.1	DRAWN BY: CLOUGH APPROVED: <i>D. West</i> HEAT TREAT FINISH SPEC 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE 1:10	DATE 1/31/2011
USED ON MODEL AW139	
SHEET 1 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		-5 ADDED FINGER CUTOUTS. -7 CHD PLACARD CUTOUT TO RECESSED. CHD MATERIAL WAS EGGSHELL IS C200 FLAT.	5/24/2011	RJC	RW
1	15-0175	-7 CHD MATERIAL WAS C200 FLAT IS Y20 BLACK. -9 DELETED CONTENT LIST FROM PLACARD. -19, -21, & -23 ADDED TO BOM.	7/17/2015	RJC	JAG



ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	GUIDE		RBW6205G11651-3G	1
				8	CLAMP		RBW6205G11451-3G	1
				1	GUIDE		RBW6205G11751-3G	1
				1	PIN	W1 TOOL STEEL	RBW6205G15551-3G	1
		B/O	-3	1	CASE	PLASTIC, BLACK	11.40 X 21.10 X 22.50 PELICAN STORM IM2875-E	N/S
		B/O	-5	1	BOTTOM FOAM	Y20 BLACK	9-1/2 X 21 X 22-1/2 IR SPECIALTY FOAM	2
		B/O	-7	1	LID FOAM	Y20 BLACK	2 X 21 X 22-1/2 IR SPECIALTY FOAM	3
			-9	1	INSIDE PLACARD	PLASTIC		4
		B/O	-11	2	CUP	CLEAR POLYSTYRENE	Ø1.77 X 4.02 (MCMaster-CARR #4611T26)	1
		B/O	-13	4	BOLT	STEEL	AN5-27A	1
		B/O	-15	8	BOLT	STEEL	AN5-10A	1
		B/O	-17	3	WASHER	ALUMINUM	Ø1/8 X .505 (MCMaster-CARR #97447A130)	N/S
		B/O	-19	1	CLAMP PLATE	ALUMINUM	#RB41011	N/S
		B/O	-21	4	PIVET	ALUMINUM	Ø1/8 X .505 (MCMaster-CARR #97447A130)	N/S
		B/O	-23	4	BLIND RIVET WASHER	ALUMINUM	Ø1/8 (MCMaster-CARR #97447A213)	N/S

NOTE:
REF. AGUSTA T/N: 3G6205G15231.
PART OF KIT RBW6205G11231-3G.

		TITLE	
		AW139 SWASHPLATE KIT	
DWG NO.		REV	
RBW6205G15231-3G		1	
MATERIAL		DRAWN BY: CLOUGH	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED: <i>D. Weir</i>	
.XXX ± .005 FRACTIONS ± 1/8		HEAT TREAT FINISH	
.XX ± .01 ANGLES ± 5°		SPEC	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		AGUSTA	
SCALE	DATE	SHEET 1 OF 4	
1:10	1/31/2011		